

Work Order ID 67635

Monday, March 28, 2011 3:54:27 PM

Page 1

Item ID: D3913-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Long Basket Base Assembly, 350

Start Date: 3/28/2011 Start Qty: 1.00

Required Date: 4/8/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: mf Date: 11-03-28 Tooling:

Date:

Run Start

QC: Date: SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3913	A
D4042	A

100 Weld per dwg A/R S.S. rod Batch: 1114659 0.00
Large Fab

Large Fab

Memo 0.00

1- assemble ribs, weld as per dwg D3913 using DT9610A
inspect before welding mesh
2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913
and trim mesh to fit if necessary and trim to clear fasteners holes on the ends
3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

110 QC9- Inspect visual per QS1004- Fusion Welds 0.00



QC

Memo 0.00

Quality Control

11.04.04
PC11.04.06

11.04.06 1 0 3E11/04/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

8/11/04/06

0.00

Memo



125



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

0.00

Memo

1 BR 11-4-7.

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Revision ID:					Stop	
Item Name:	Long Basket Base Assembly, 350					
Start Date:	3/28/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	4/8/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
	<i>M116964</i>					<i>1</i>		<i>BR 11-4-7</i>	
	Powdercoat	0.00							
	Powder Coating								
	1- Plug holes and mask only interior of hinge (3) prior to powder coat								
	IST COAT:								
	START TIME: <i>1:40</i>								
	OVEN TEMPERATURE: <i>400°</i>								
	FINISH TIME: <i>2:10</i>								
	***** 2nd coat if necessary*****								
	2ND COAT:								
	START TIME: _____								
	OVEN TEMPERATURE: _____								
	FINISH TIME: _____								
140 	QC3- Inspect Part Finish	0.00							
	QC	0.00							
	Quality Control								
						<i>1</i>	<i>0</i>	<i>11/04/07</i>	

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Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



HandFinish

✓ Assemble as per dwg

0.00

Memo

0.00

Hand Finishing

Pick Kit

1 0 11/05/07

160



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

5 w/04/08

0

170



Packaging

Identify as per dwg & Stock Location: w/o

0.00

Memo

0.00

Packaging

D4030-041 / B67633

1 0 11/05/07

W/O:		WORK ORDER CHANGES					
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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/8-*[Signature]*
11-04-8
①

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Picklist Print

Monday, March 28, 2011 3:54:24 PM

Page 1

Work Order ID: 67635

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350





Start Date: 3/28/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-10A  Bolt		Purchased	No			150	Each	46.0000	6	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		46							
					116400	46							
AN960JD8  Washer	NAS1149DN832J	Purchased	No			150	Each	0.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		38							
					66500	14							
					66806	24							
D2581  Mounting Bracket		Manufactured	No			100	Each	38.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		38							
					66500	14							
					66806	24							
D2931  Bumper		Manufactured	No			150	Each	704.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		704							
					46064	704							

116400
2 11/04/04
117316

2 11-04-04

(20)

2 11/04/04

x2

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Page 2

Work Order ID: 67635

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/28/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D3913-1 Manufactured No 100 Each 3.0000 1 1

 Rib

Location Loc Qty Loc Code

WA006 3
 66629 3

✓ D3913-15 Manufactured No 100 Each 3.0000 1

 Wide Handle Plate

Location Loc Qty Loc Code

WA005 3
 66695 3

✓ D3913-3 Manufactured No 100 Each 2.0000 1

 Rib

Location Loc Qty Loc Code

WA006 2
 65314 1
 65852 1

✓ D3913-7 Manufactured No 100 Each 8.0000 2

 Rib

Location Loc Qty Loc Code

WA006 8
 65278 2
 66435 6

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Page 4

Work Order ID: 67635

Parent Item: D3913-041


Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/28/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4017-7 Manufactured No 100 Each 4.0000 1 1

 Rib

Location Loc Qty Loc Code

WA005

4

66546


1

66885

3



11.04.04

✓ D4017-9 Manufactured No 100 Each 6.0000 2 2

 Rib

Location Loc Qty Loc Code

WA006


6

66886

6



11.04.04

✓ D4020-11 Manufactured No 100 Each 7.0000 2 2

 End Mesh, Basket

Location Loc Qty Loc Code

WA

7

61306


1

67094

6



11.04.04

✓ D4021-1 Manufactured No 100 Each 11.0000 3 3

 Handle Plate

Location Loc Qty Loc Code

WA005

11

56044

3

66697

8



11.04.04

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Shop Packet Print

Page 4

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Page 5

Work Order ID: 67635



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/28/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

D4021-5 Manufactured No

150 Each

13.0000

2

2



Blanking Plate



ell 11.04.06

Location

Loc Qty

Loc Code

ST110

1

65675

1

WA005

12

67008

12

✓ D4034-041

Manufactured No

100

Each

4.0000

1



Aft Upper Rib Assembly



11.04.04

Location

Loc Qty

Loc Code

WA006

4

66536

1

66884

3

✓ D4034-043

Manufactured No

100

Each

3.0000

1



Fwd Upper Rib Assembly



11.04.04

Location

Loc Qty

Loc Code

WA006

3

66883

3

✓ M304EX0.75-16F

Purchased

No

100

sf

630.0000

33



Expanded Metal Flat SS



11.04.06

Location

Loc Qty

Loc Code

WA

630

115012

150

117197

480

Monday, March 28, 2011 3:54:25 PM

Shop Packet Print

Page 5

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Monday, March 28, 2011 3:54:25 PM

Page 6

Work Order ID: 67635

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/28/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

150

Each

1,075.000

2

2



Cherry Rivets

Location

Loc Qty

Loc Code

ST321

542

111636

542

WA018

533

107939

533

116636

MS21042L3

Purchased

No

150

Each

2,191.000

6

6



Nut

Location

Loc Qty

Loc Code

ST300

2191

116391

591

116540

800

116549

800

116391

NAS1149F0332P

Purchased

No

150

Each

62.0000

12

12



WASHER

Location

Loc Qty

Loc Code

ST275

62

18057

62

117317 3p

18057 9p

Monday, March 28, 2011 3:54:25 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

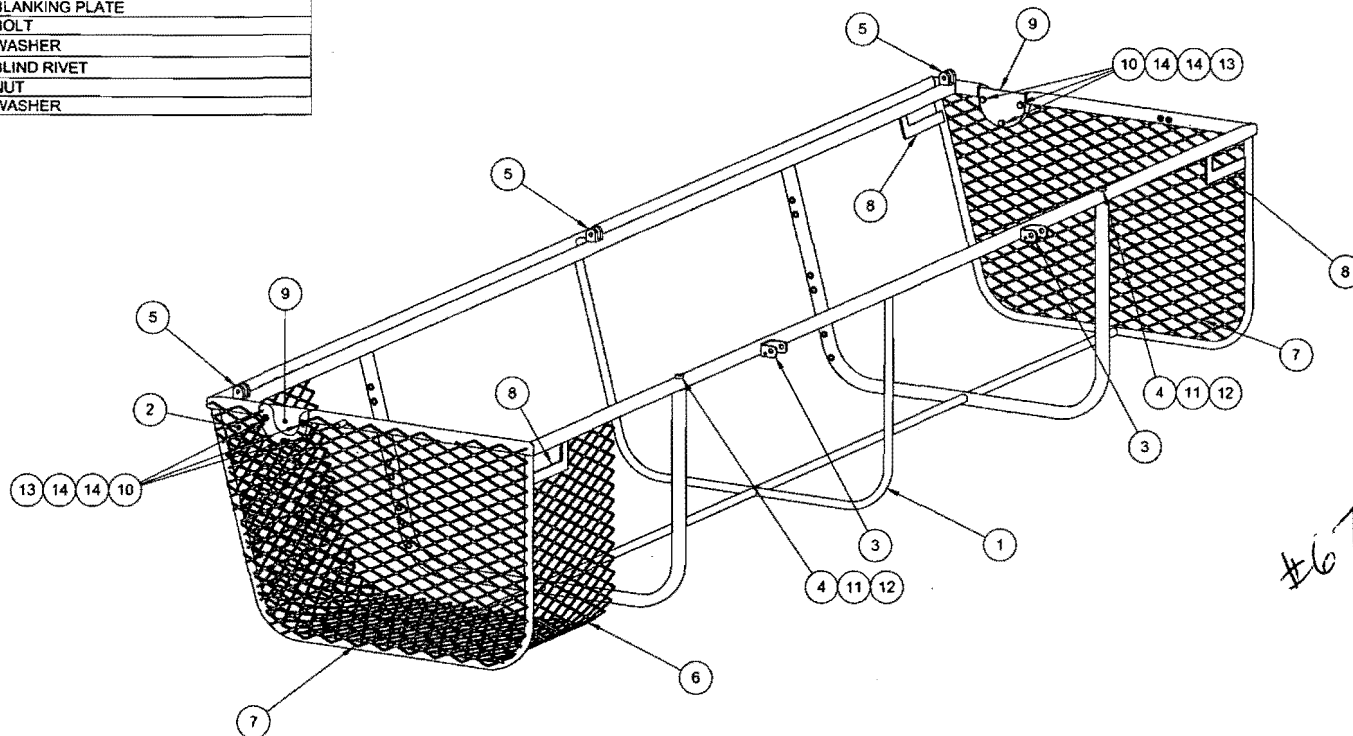
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
2010-03-22
WJP

#67635

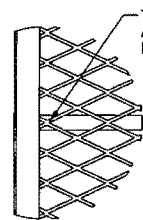
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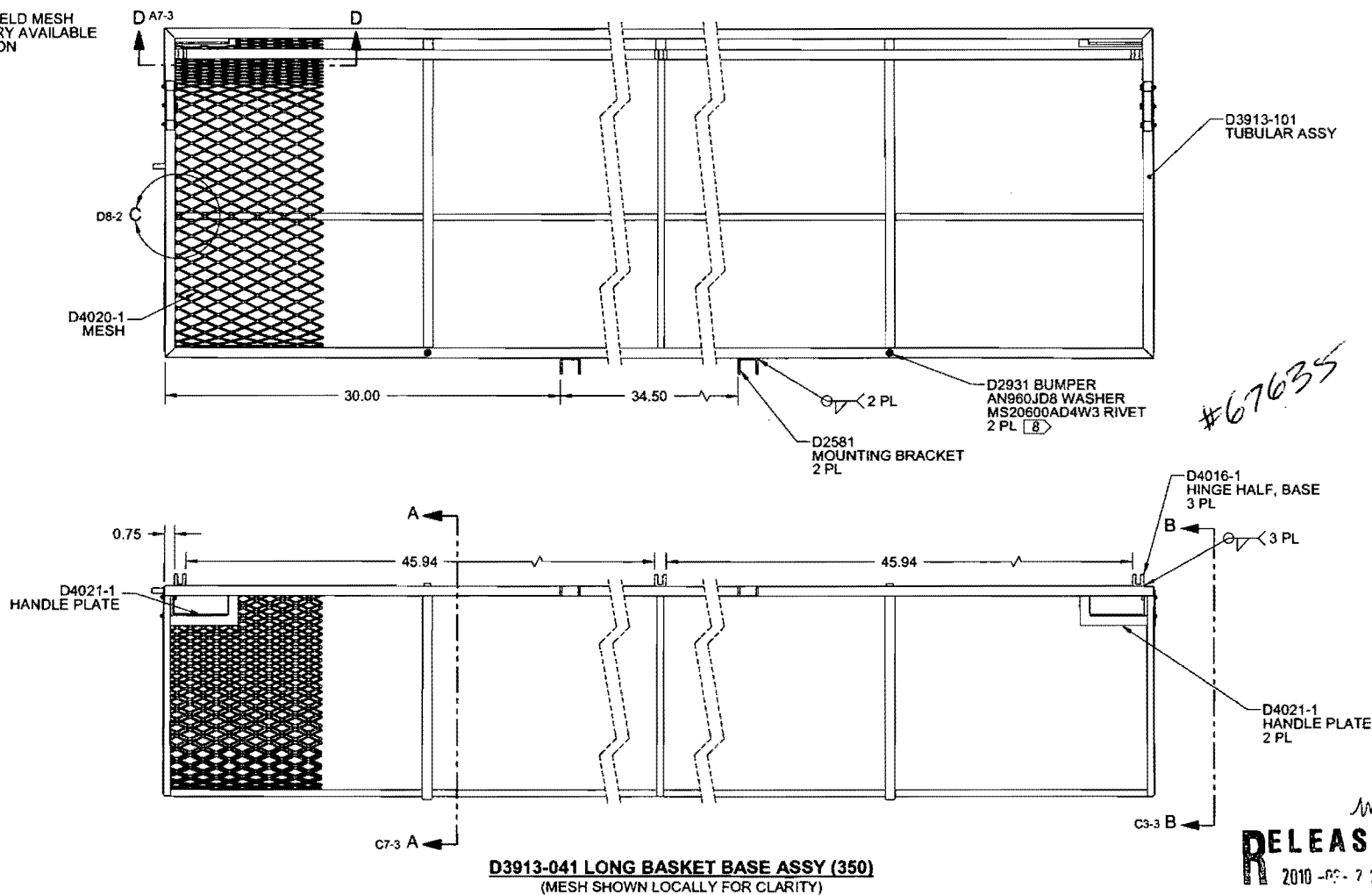
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NOTE: Date & initial all entries



DETAIL C D7-2



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-05-27

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO. D3913	REV. A
MFG. APPR.		TITLE	SHEET 2 OF 6
APPROVED		LONG BASKET BASE ASSY (350) NTS	
DE APPR.			
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

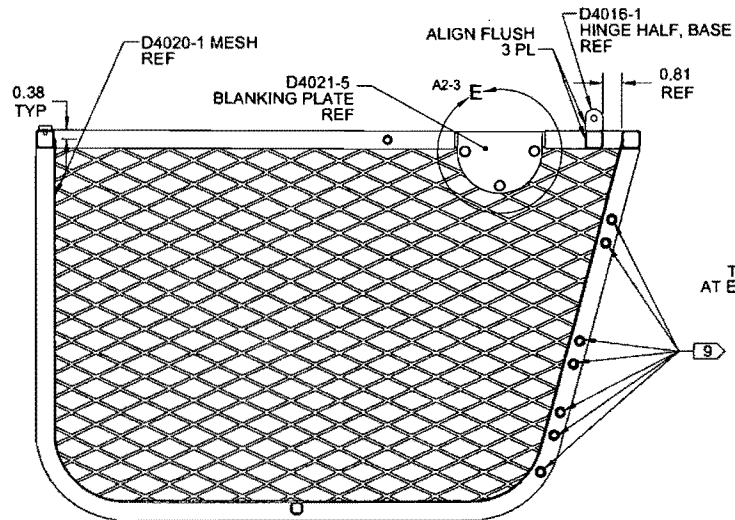
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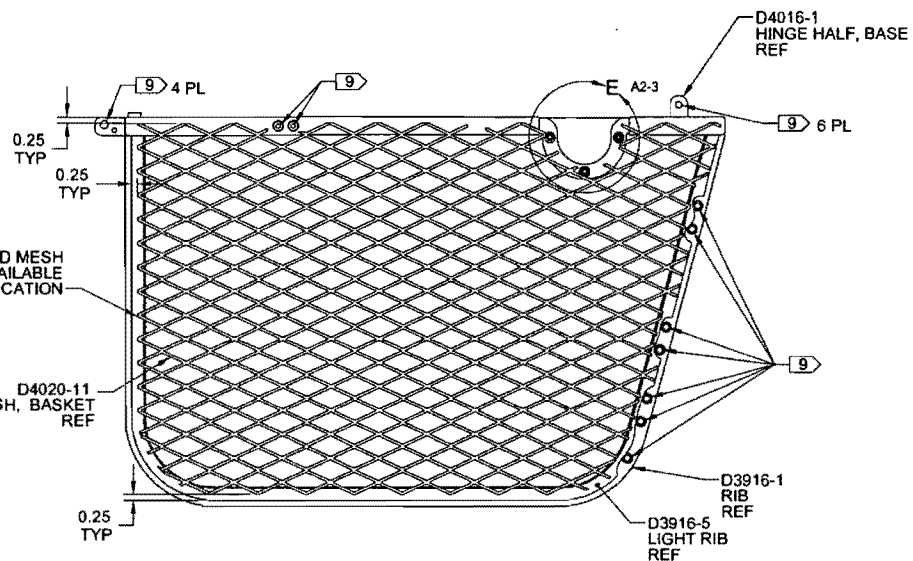
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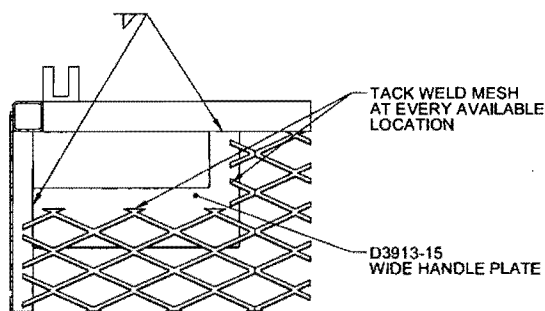
NOTE: Date & initial all entries



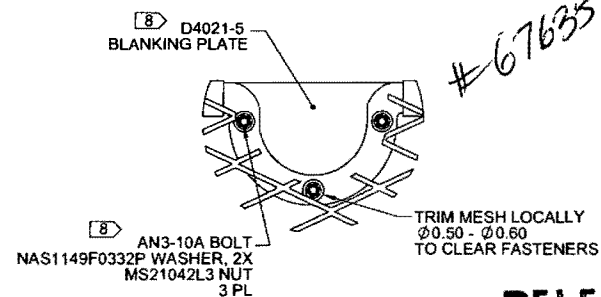
SECTION A-A A5-2







VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL D2-3
D6-3

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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RELEASED
2010-03-22

#67635

IND

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

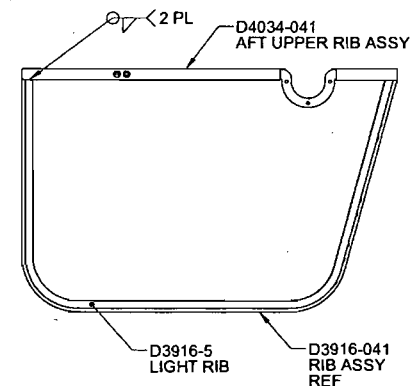
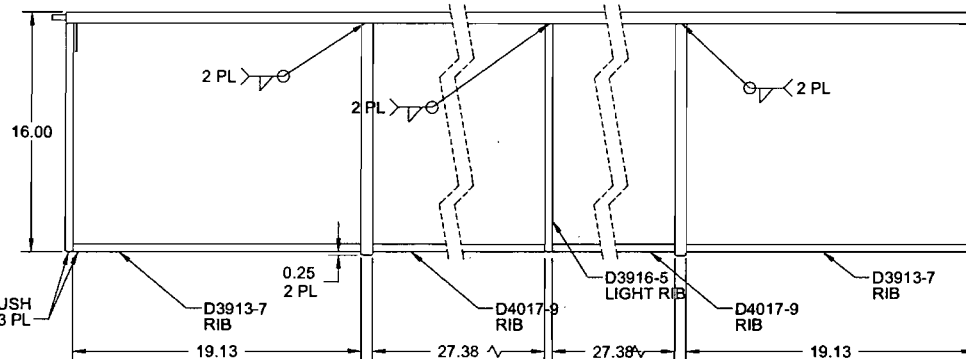
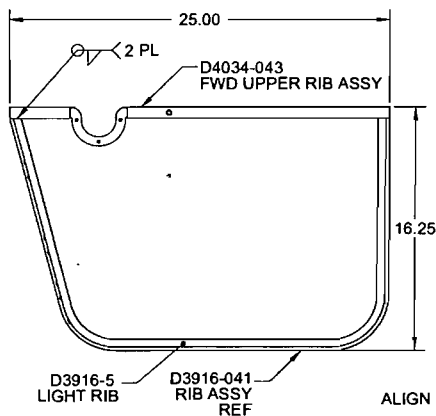
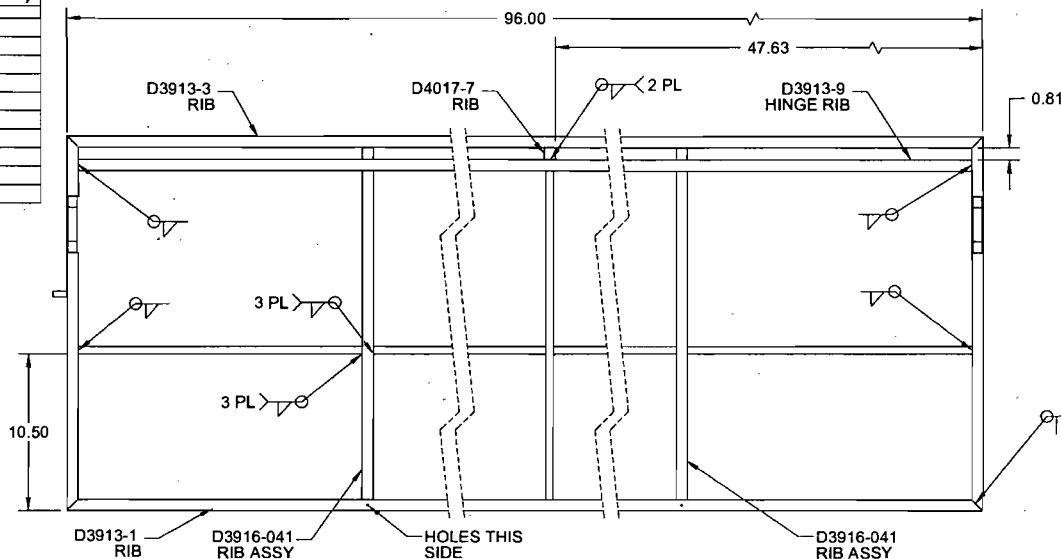
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	A/S	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED	A	DRAWING NO. D3913
MFG. APPR.		SHEET 4 OF 6
APPROVED		TITLE LONG BASKET BASE ASSY (350) NTS
DE APPR.		SCALE
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

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2010-03-22

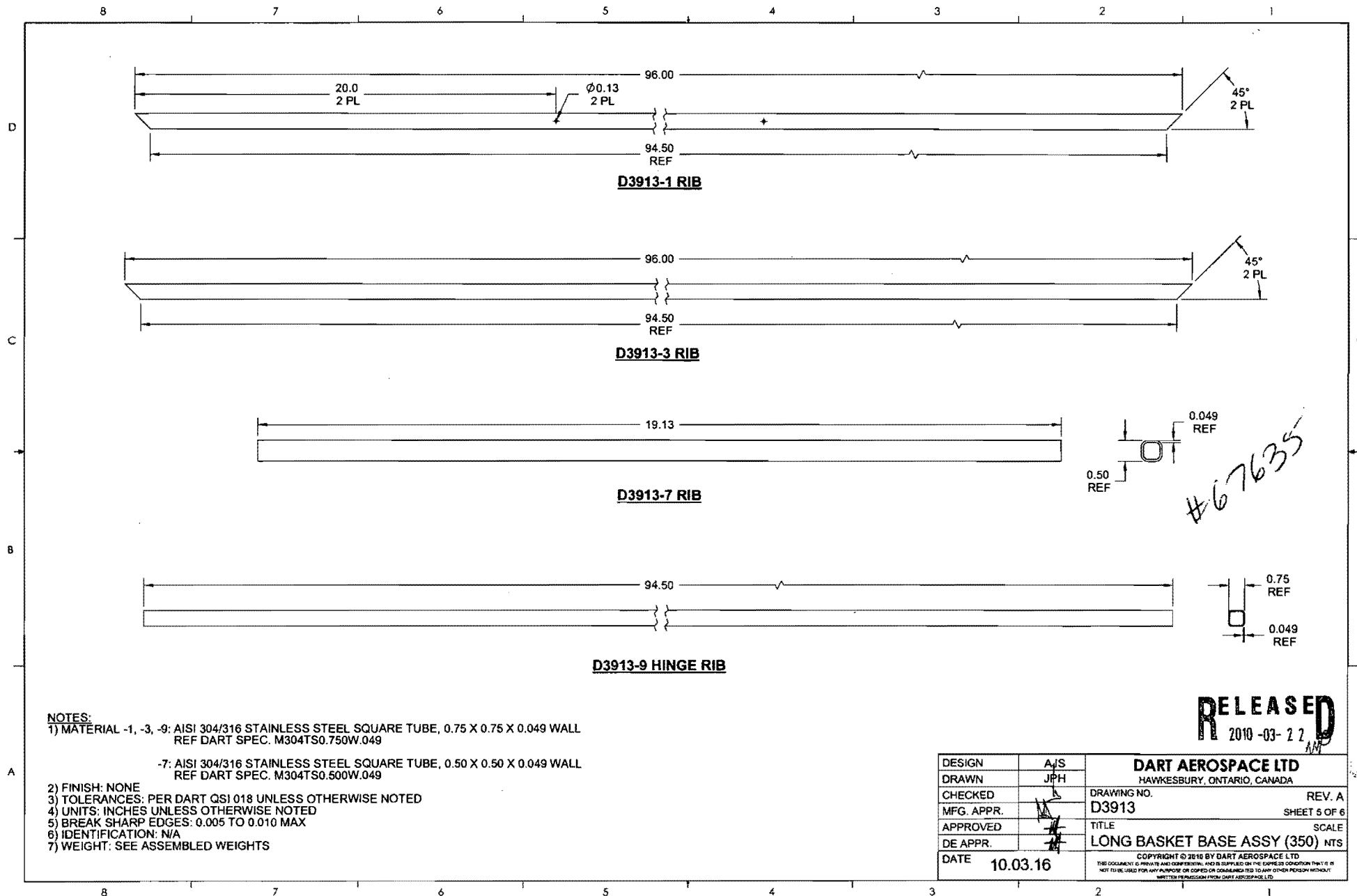
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



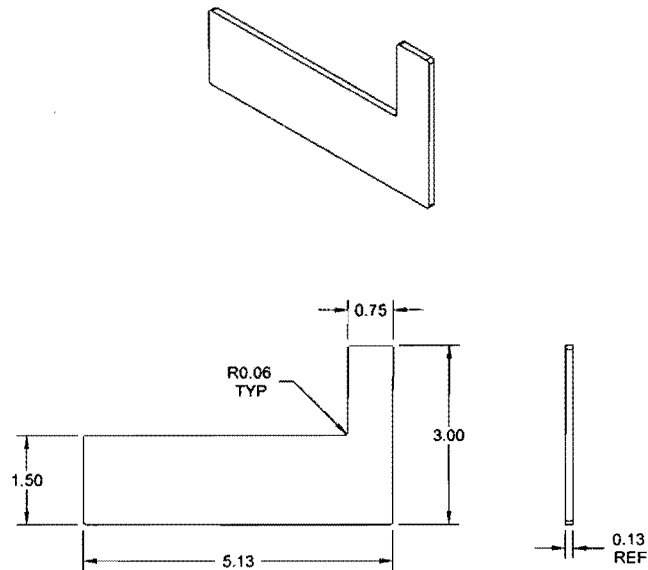
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

#67635

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2010-03-22
JAP

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries